Work Ord June-12-13 9:1		02788		*102788*							Page :			
Item ID: Revision ID: Item Name:	D3255-5 Gasket			Accept	*N900	<u>040</u>	100)* s	etup Star	1 /1	S1* S2*			
Start Date: Required Date: Reference:	6/11/13	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item I Customer:	ID:				14	. 12 - 3			
Approvals:	Process P	lan: MLJ	. —			ate:		R	tun Star Sto		R1* R2*			
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject. Qty	Reject Number	Insp. Stamp	· · · · · · · · · · · · · · · · · · ·		
Draw Nbr	Re	evision Nbr												
D3255	Re	ev B												
*100		FLOW WATER JET		0.00				3	٥		JMB	P-06-7.3		
Waterjet FLOW CNC Waterj	jet	Dwg Rev:_		0.00								- 1		
•		Prog Rev:2-Deburr if												
*110 *110*		QC2- Inspect parts off m	nachine FAI/FAIB	0.00				0	٥.		Im.2	LC-20-		
QC		Memo		0.00								. ८०. ४५		

Quality Control

DQA: Date: WORK ORDER NON-CONFORMANCE / UPDATE									*DART			
QA Closed:		Date:			WORK ORDER NON-	-	JINFO	RIVIANCE / OPDATE	W	ork Order up	odate only	AEROSPACE
Work Orde	ır.				DISPOSITION			AGAINST	r DE	PARTMENT	/PROCESS	
WOIK OIGE					Rework	ıl	Skid-tube Crosstube			1	Water Jet	Engineering
Part N	lo				Scrap			Machining Small Fab		Pro	d. Eng. Coor.	Quality
NCR N	NCR No.			_	Use-as-is Suspected Unapproved		Therr	noforming Finishing Large Fab Composite	_	Rec/Sto	re/Packaging Supplier	Other
Root				Descr	ription of work order update	ı	nitial	Action		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design	1											
Doc/Data												
Equip/Tooling												
Handling/Pre												
Material												
Operator												
Offset/Setup							C'-#9					
Process						}						
Supplier												
Training						1						
Transport												
Unapproved												
						FAI	ULT CA	TEGORY	-			
Landir	ng Gear				General							
	Bendin	g			Bend		Folio/	Program		Outside Dim	ensions	Pressure/Forced
	Centre	Not Conce	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
1	Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	ct	Temperature/Cure
[Crimp/I	Kink/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	issing	Weld
	Cuffs				Contamination		Instruc	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
	Crushin	g			Countersink		•	gned/off center		Positioned V		-
	Heat Treat			Cut Too Short		Mislab	eled		Power Loss/	Surge	Other	
	Inspection Strip in Tube			Drawing		Misrea	d	_	_	_		
	Marks/	Chatter			Drill Holes		Off-set					
	Turning	Sequence	•		Finish	\Box	Out of	Calibration				
	Wave/Twist in Tube				Fit/Function		4	Sequence				

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Work Order ID June-12-13 9:14:07 AM	102788	*10				Page 2		
Item ID: D3255-5 Revision ID: Item Name: Gasket		Accept	*N9000401	იი*	Setup	Start Stop	i VI .	S1*
Start Date: 6/11/13 Required Date: 6/11/13 Reference:	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*	Cust Item ID: Customer:				IV.	
Approvals: Process		Tooling: SPC (Y/N):	Date:Date:		Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID Tool # Pl	an Acce	pt Rejo		Reject Number	Insp. Stamp
*120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	§ 5 ⊃ 8	8				
*130 *130* Packaging Packaging	Identify as per dwg & Stock Locati	on: WA 0.00		_8			M. hl.	13-06-
*140 *1 4 0*	QC21- Final Inspection - Work Ord	ler Release 0.00				13	1/8	r D

Quality Control

MF 7-8

DQA:			Date:				WORK ORDER NON-CONFORMANCE / UPDATE								
QA Closed:			Date:			WORK ORDER NON-	-CC	JNFOI	RMANCE / U		Wo	ork Order up	date only	AEROSPACE	
Work Orde		. . .				DISPOSITION				AGAINST	DEF	PARTMENT/	PROCESS		
WOIK OIGE	- '				-	Rework	1	•	Skid-tube	Crosstube	\neg		Water Jet	Engineering	
Part N	lo.					Scrap			Machining Machining	Small Fab	\dashv	Pro	d. Eng. Coor.	Quality	
raiti	' '. –					Use-as-is			noforming	Finishing			e/Packaging	Other	
NCR No.			Suspected Unapproved		THETT	Large Fab	Composite	\dashv	rice, stor	Supplier					
	_				_		,			111111111111111111111111111111111111111				J LJ	
Root					Desci	ription of work order update		nitial	Act	tion	Ĭ	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desci	ription		Date	Verification	QC Inspector	
Design									-						
Doc/Data															
Equip/Tooling	Ц										i				
Handling/Pre	Щ														
Material															
Operator	Ш														
Offset/Setup	Ш														
Process	Ц														
Supplier	Ц														
Training	Ш					,									
Transport	Ц														
Unapproved							<u> </u>		<u> </u>						
							FAI	ULT CA	TEGORY						
Landi						General		1 ,_	_	•		l	_	-	
	\vdash	Bending			-	Bend			Program			Outside Dim	 	Pressure/Forced	
	⊢		ot Concer	ntric	-	BOM/Route	_	Grain			_	Over/Under	<u> </u>	Set-up	
	\vdash	Cracks	l (n: 1	6	<u> </u>	Broken/Damage/Defect		Hardwa			-	Part Incorred	<u> </u>	Temperature/Cure	
	\vdash	-	nk/Ripple	/Wave		Burrs	<u> </u>	1 '	ion Incomplete/U	•	_	Part Lost/Mi	ssing	Weld	
	\vdash	Cuffs			\vdash	Contamination	<u> </u>	•	tions Incomplete/	Unclear		Part Moved	L	Wrong Stock Pulled	
	Crushing			\vdash	Countersink	<u> </u>	1	gned/off center		-	Positioned V		-		
	Heat Treat			<u> </u>	Cut Too Short	<u> </u>	Mislabe				Power Loss/	Surge	Other		
	\vdash	-	n Strip in	Tube	<u> </u>	Drawing	_	Misrea							
,	-	Marks/Ch			<u> </u>	Drill Holes	<u> </u>	Off-set							
	Turning Sequence				-	Finish Fit/Function	-	1	Calibration						
	Wave/Twist in Tube			10		I FIT / FII IN CTION	1	IClust of	Saguanca						

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Picklist Print

June-12-13 9:14:07 AM

Work Order ID:

102788

Parent Item:

D3255-5

Parent Item Name:

Gasket

Start Date: 6/11/13

Required Date: 6/11/13

Page 1

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP A04.05.12New issueKJ/RF

IPP Rev:B Now On Wateriet 06-08-14 JLM

	III Rev.B 110W	On waterjet 00-00	-1 + JLIVI										
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3255		Manufactured	No			110	sf	48.0000	1.5411	12.077684	ļ		-
Gasket	•									<u>اي . د</u>)		J <u>~13-</u> 04

 Location
 Loc Qty
 Loc Code

 MAT052
 48

99492 48

99492

DQA:	—— Date: ————————————————————————————————————												
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UI		Work Order u	odate only	AEROSPACE
						DISPOSITION					DEPARTMENT	·	
Work Orde	er: _					DISPOSITION	. 1						
						Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part N	No. ِ					Scrap		!	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
							Finishing	Rec/Sto	re/Packaging	Other			
NCR I	۱o. ₋					Suspected Unapproved	pected Unapproved Large Fab Composite				Supplier		
Root	Root De			Desci	ription of work order update		nitial	Act	ion	Sign &			
Cause		Date	Step	Qty	1 1		1	ief Eng		iption	Date	Verification	QC Inspector
Design	\Box		<u> </u>							•			•
Doc/Data	П												
Equip/Tooling													
Handling/Pre													
Material													
Operator													
Offset/Setup													
Process			ŀ				l						
Supplier													
Training							ĺ						
Transport					in a	Y4.							
Unapproved													
							FAI	ULT CAT	regory				
Landi	ng G	Gear				General				_		_	
	Ш	Bending				Bend		Folio/F	rogram		Outside Din	nensions	Pressure/Forced
	Ш	Centre N	ot Concei	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorre	ct	Temperature/Cure
	Ш	Crimp/Ki	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Ur	nqualified	Part Lost/M	issing	Weld
	Ш	Cuffs				Contamination		Instruct	ions Incomplete/U	Jnclear	Part Moved		Wrong Stock Pulled
	Crushing			Countersink		Misalig	ned/off center		Positioned \	Wrong			
	Heat Treat		Cut Too Short		Mislabe	eled		Power Loss,	/Surge	Other			
Inspection Strip in Tube			Drawing		Misread	t							
		Marks/Cl	natter			Drill Holes		Off-set					
		Turning S	Sequence			Finish		Out of 0	Calibration				
	Wave/Twist in Tube			эe		Fit/Function		Out of	Sequence				

DART AEROSPACE LTD	Work Order:	102 788
Description: Gasket	Part Number:	D3255-5
Inspection Dwg: D3255 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/-0.030	1.06	_		V	Jemo,
18.46	+/-0.030	18.46	_		T	Jemos Jemos Produsor
11.43	+/-0.030	11.43"	-		V	Produsor
15.36	+/-0.030	15.36)		P	
6.90	+/-0.030	6.90"			ν	
0.063	+/-0.010	6.060			7	
						- Palada.
						71/ E 1/s
						7
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				· ·		

Measured by:	Jm	Audited by:	27	Prototype Approval:	N/A
Date:	13-06-27	Date:	B628	Date:	N/A

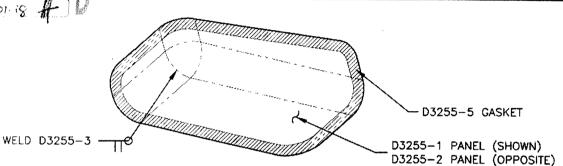
Rev	Date	Change	Revised by	Approved
_ A	07.07.18	New Issue	KJ/JLM	B

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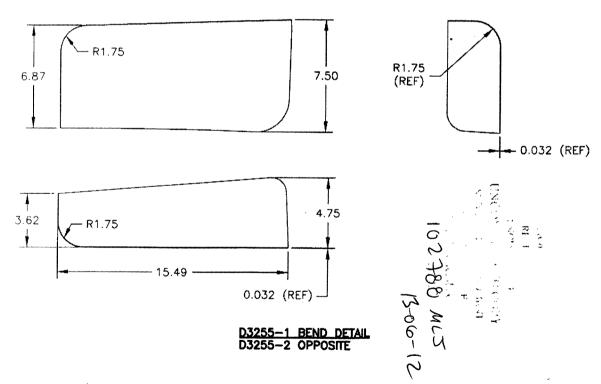


	DESIG	N i착	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
	CHEC	KED . ()	APPROVED	DRAWING NO. REV. B		
		W	-	D3255 SHEET 1 OF 4		
	DATE			TITLE SCALE		
	04.12.06			ACCESS PANEL ASSEMBLY 1:6		
	Α		04.01.27	NEW ISSUE		
	В		04.12.06	D3255-3 REDESIGN; ADDED Ø0.098		





D3255-041 ACCESS PANEL (SHOWN) D3255-042 ACCESS PANEL (OPPOSITE)



D3255-041/-042 NOTES;

1) WELD PER DART QSI 004
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS

4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

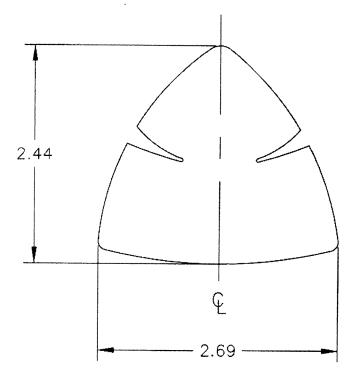
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CHECKED	APPROVED	DRAWING NO. D3255	REV. B SHEET 2 OF 4		
DATE	···	TITLE	SCALE		
04.12.06		TITLE	1:1		





D3255-3 CAP FORM TO FIT D3155-1/-2

<u>D3255-3 NOTES:</u>

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLÈSS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

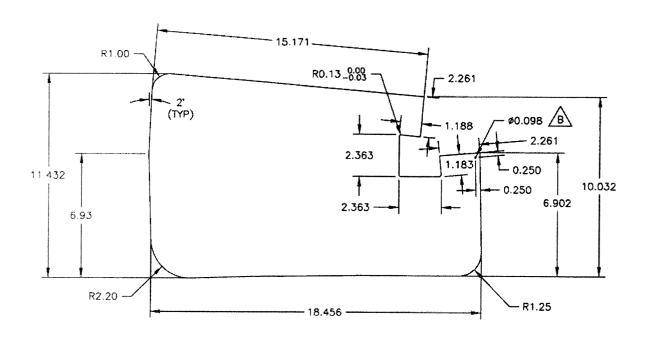
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CHECKED	APPROVED	D3255	REV. B SHEET 3 OF 4	
DATE		TITLE	SCALE	
04.12.06		ACCESS PANEL ASSEMBLY	1:5	





D3255-1/-2 FLAT PATTERN

D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

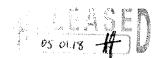
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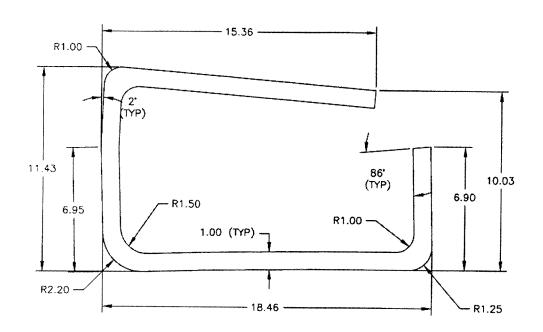
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CHECKED	APPROVED	DRAWING NO. D3255	SHEET	REV. 4 OF	-
DATE		TITLE		SCA	LE
04.12.06		ACCESS PANEL ASSEMBLY			1:5





D3255-5 GASKET

D3255-5 NOTES:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F P/N SIL/F 36x36x1/16 POSSIBLE SUPPLER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES

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